

Work Order ID 66155-2

Monday, February 07, 2011 11:20:49 AM

SP/it



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

(35)

Start Date: 2/8/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-02-07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

EJ 11/02/28 (35)

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

EJ 11/02/28

cont
(+35)

120



Small Fab

0.00

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ***DO NOT TIGHTEN
BOLTS*** Identify as D3278-041

EJ 11/03/01 (35)

Work Order ID 66155

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Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

Stop



Start Date: 2/8/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 110314

Counted
+35

140



Packaging

Packaging

Identify as per dwg & Stock Location: 471

0.00

11/3/2011 35 SF

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/03/03 JJ

PL 11-03-2
35

Picklist Print

Monday, February 07, 2011 11:20:46 AM

Page 1
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Work Order ID: 66155



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: A 04.04.19 New issue KJ/JLM
IPP: B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A 		Purchased	No			120	Each	682.0000	2	120		E/S 11/03/01	
-------------	--	-----------	----	--	--	-----	------	----------	---	-----	--	--------------	--

Bolt

Location	Loc Qty	Loc Code
ST357	682	
116191	7	
116669	375	
116786	300	

AN960JD416

NAS1149D0463J Purchased

No:

M116805 (140)

Washer

AN960JD416 	NAS1149D0463J	Purchased	No:			120	Each	30.0000	4	240		E/S 11/03/01	
----------------	---------------	-----------	-----	--	--	-----	------	---------	---	-----	--	--------------	--

Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

D2230-I

Manufactured

No:

Lug

D2230-I 	Manufactured	No:				120	Each	61.0000	2	120		E/S 11/03/01	
-------------	--------------	-----	--	--	--	-----	------	---------	---	-----	--	--------------	--

Location	Loc Qty	Loc Code
ST476	61	
64423	61	

27 B65276 (43x)

Picklist Print

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Work Order ID: 66155



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

D3278-1



Support

Manufactured No

100

Each

11.0000

1

60



EJ 11/02/28

B65074 (35x)

~~60~~

D3278-2



Support

Manufactured No

100

Each

10.0000

1

60



EJ 11/02/28

B65075 (35x)

~~60~~

D3278-3



Spacer

Manufactured No

100

Each

69.0000

1

60



EJ 11/02/28

~~60~~

~~30~~ 30

~~5~~ 5

Picklist Print

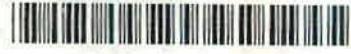
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Work Order ID: 66155



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

MS20426AD3-6

Purchased

No

120

Each

4,641.000

4

240



Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST316	4641	
105055	1071	
116289	3570	

EJS 1/02/18

140

MS21042L4

Purchased

No

100

Each

3,720.000

2

120



Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3720	
1123143	2	
115589	10	
115621	21	
116188	3500	
116548	187	

EJS 1/03/18

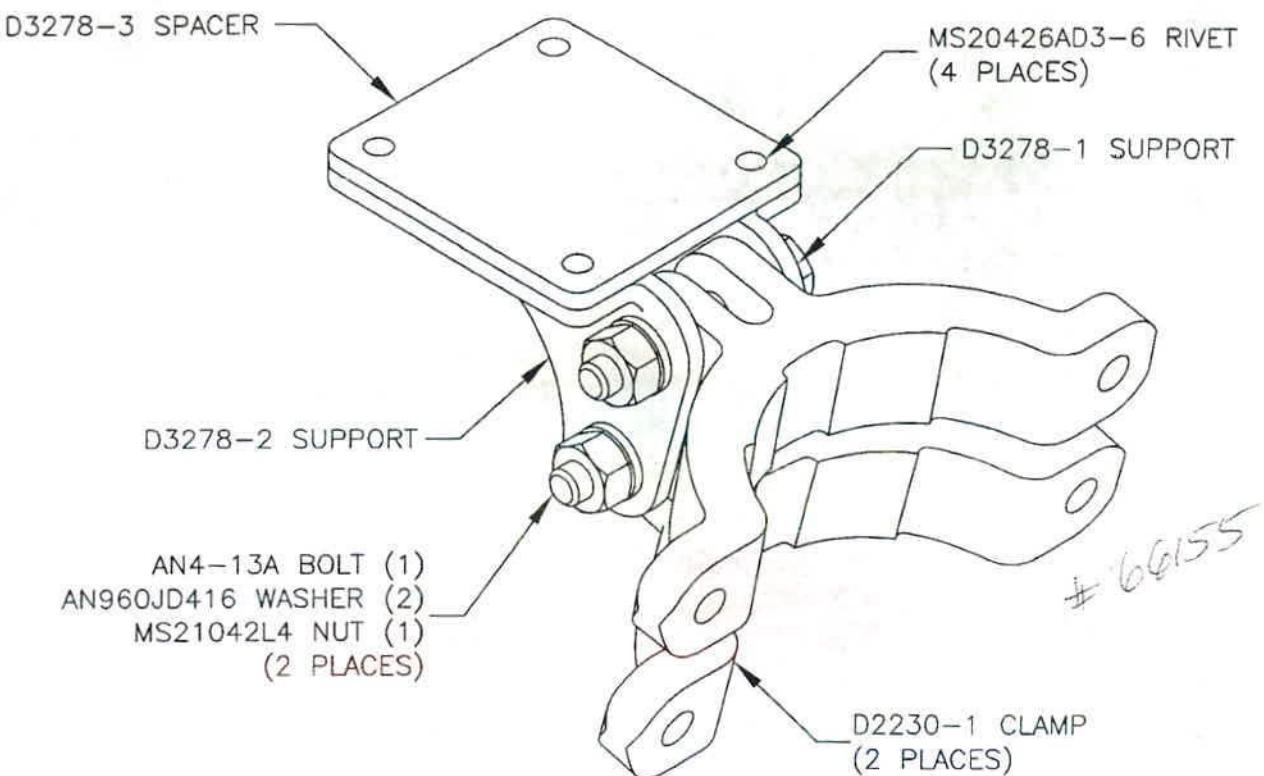
35

DART

DESIGN <i>QP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>JH</i>	DRAWING NO. D3278
DATE 07.07.24		REV. C SHEET 1 OF 3
		TITLE SUPPORT ASSEMBLY
		SCALE NTS

RELEASED
07.08.08

D3278-041 SUPPORT ASSEMBLY



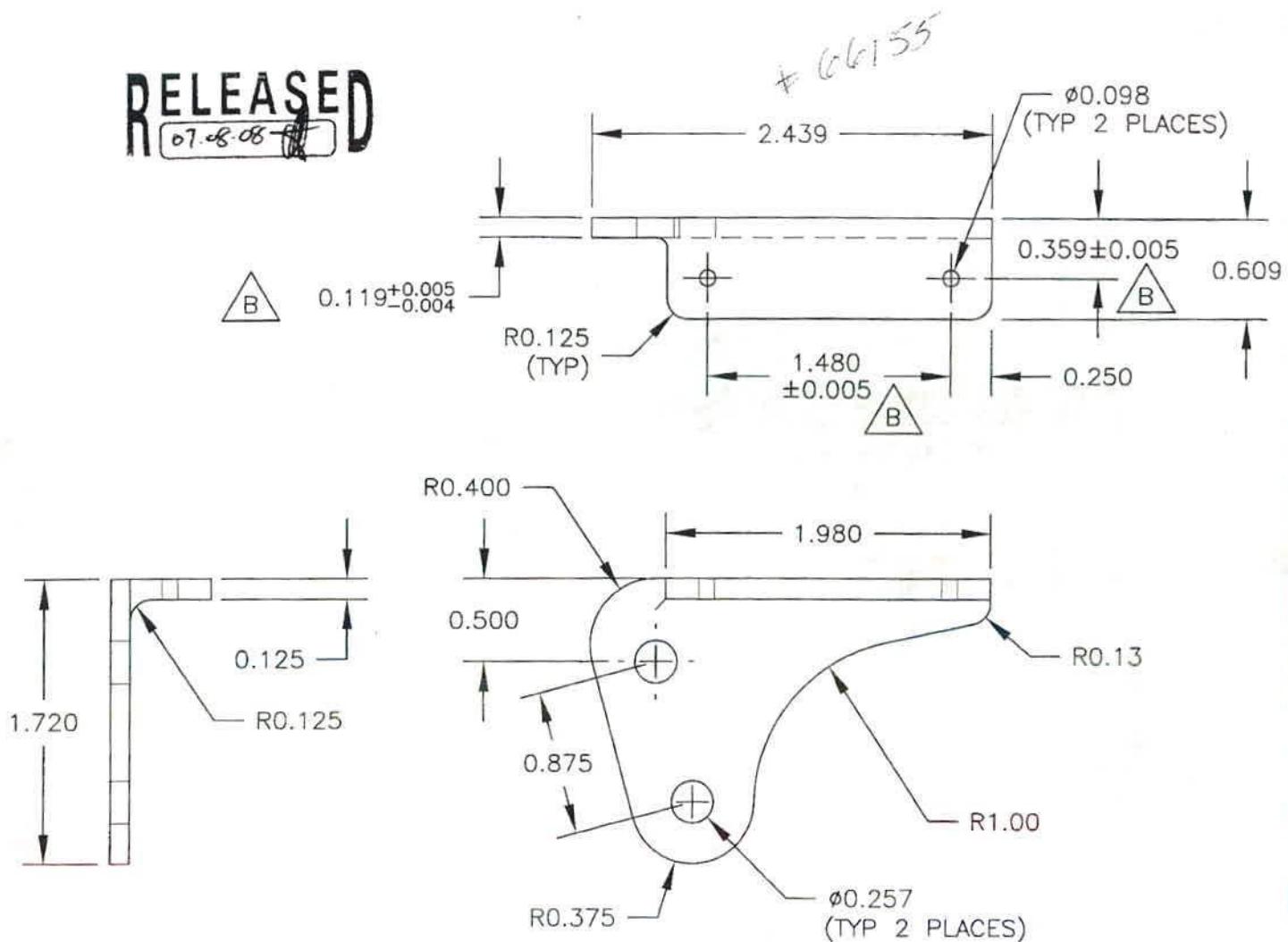
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DART

DESIGN <i>QP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY	SCALE 1:1	

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

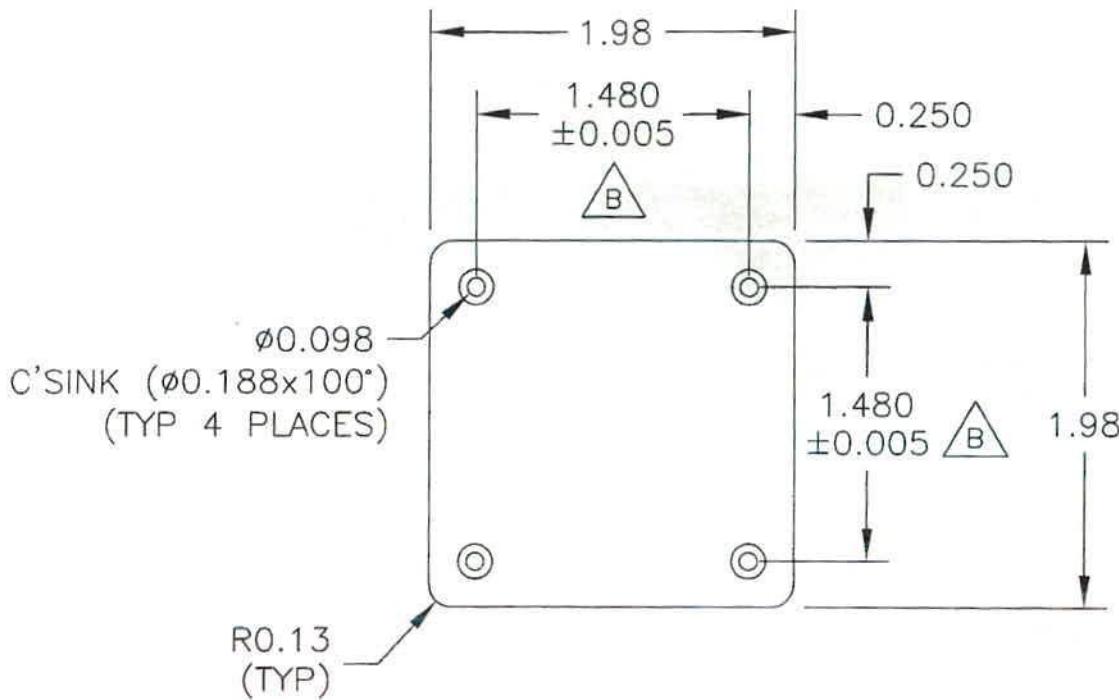
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART

DESIGN <i>99</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24	TITLE SUPPORT ASSEMBLY	REV. C SHEET 3 OF 3 SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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